

Claims

1. A coated cutting tool insert of cemented carbide with a coating including at least one layer of  $Ti_{1-x}Al_xN$  deposited by PVD-technique c h a r a c t e r i s e d in  
5 that  $x=0.4-0.6$  with a compressive residual stress of  $>4-6$  GPa and a thickness of  $1.5-5$ , preferably  $2.5-4$ ,  $\mu m$ ; both the intensities of the (111) and (200) reflections,  $I(111)$  and  $I(200)$ , are  $<7.5$ , preferably  $<5$  times, the intensity average noise level.
- 10 2. Method of making a coated cutting tool insert of cemented carbide with a coating including at least one layer of  $Ti_{1-x}Al_xN$  deposited by PVD-technique c h a r a c t e r i s e d in depositing the layer with a bias,  $U$ , in the range  $-90 < U < -50V$ , preferably  $-80V < U < -$   
15  $60V$ ; with a nitrogen pressure in the range of  $20-40$   $\mu bar$ ; arc current in the range  $160-220$  A and temperature in the range  $400-600$   $^{\circ}C$ .